

Date: Thursday, 5/10/2007 2:26:35 PM
User: Kim Johnston

Process Sheet

split
8B 07/05/31

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOOR ASSEMBLY
Job Number :	32288		
Estimate Number :	11403		
P.O. Number :	<i>N/A</i>	Part Number :	D3296041
This Issue :	5/10/2007	S.O. No. :	<i>N/A</i>
Prsht Rev. :	NC	Drawing Number :	D3296 REV A
First Issue :	<i>N/A</i>	Project Number :	N/A
Previous Run :	31302	Drawing Revision :	A
	Type :	Material :	<i>N/A</i>
		Due Date :	5/30/2007
Written By :		Qty:	10 Um: Each
Checked & Approved By :	<i>07.05.10</i>		
Comment :	Est. C 05.10.14 Added step 14 KJ/EC Est Rev:D Revised Steps 06-11-20 JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D32961 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	<i>D32367</i>

FF 07-05-31 4

2.0 D32963 Door Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door	Panel	<i>D32360</i>

FF 07-05-31 4

3.0 D31617 Hinge 14"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Hinge 14"

Batch: *D32364*

FF 07-05-31 4

4.0 D31619 Hinge 17"



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Hinge 17"

Batch: *D32365*

FF 07-05-31 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05/05/31	1	split w/o	SB	05/05/31	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/05/31	1	split w/o			SB			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 32288

Part Number: D3296041

Job Number:



Seq. #

Machine Or Operation:

Description:

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total: 250.0000 Each(s)

Rivet, Universal Head

Batch: M104214

FF 07-06-01

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Fabricate & assemble as per Dwg D3296.

FF 07-06-01

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/01 (4)

8.1

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-H 07/06/02

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-06-04

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal 31330

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D2419 Handle 31331

P 7/6/4 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:26:35 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 32288

Part Number: D3296041

Job Number:



Seq. # Machine Or Operation: Description:

12.0

D24620040

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0040 Seal

B29456 RLY

13.0

D24620053

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0053 Seal

B29456

14.0

D24620245

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0245 Seal

B29456

15.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

B24215

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

6085

R 7/6/4 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

File:
User:

Thursday, 5/10/2017 1:26:35 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 32288

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M103691

10/16/14 (4)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

mf 07-06-04 (4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/04 (4)

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/06/04 (4)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

07/06/04

Job Completion:



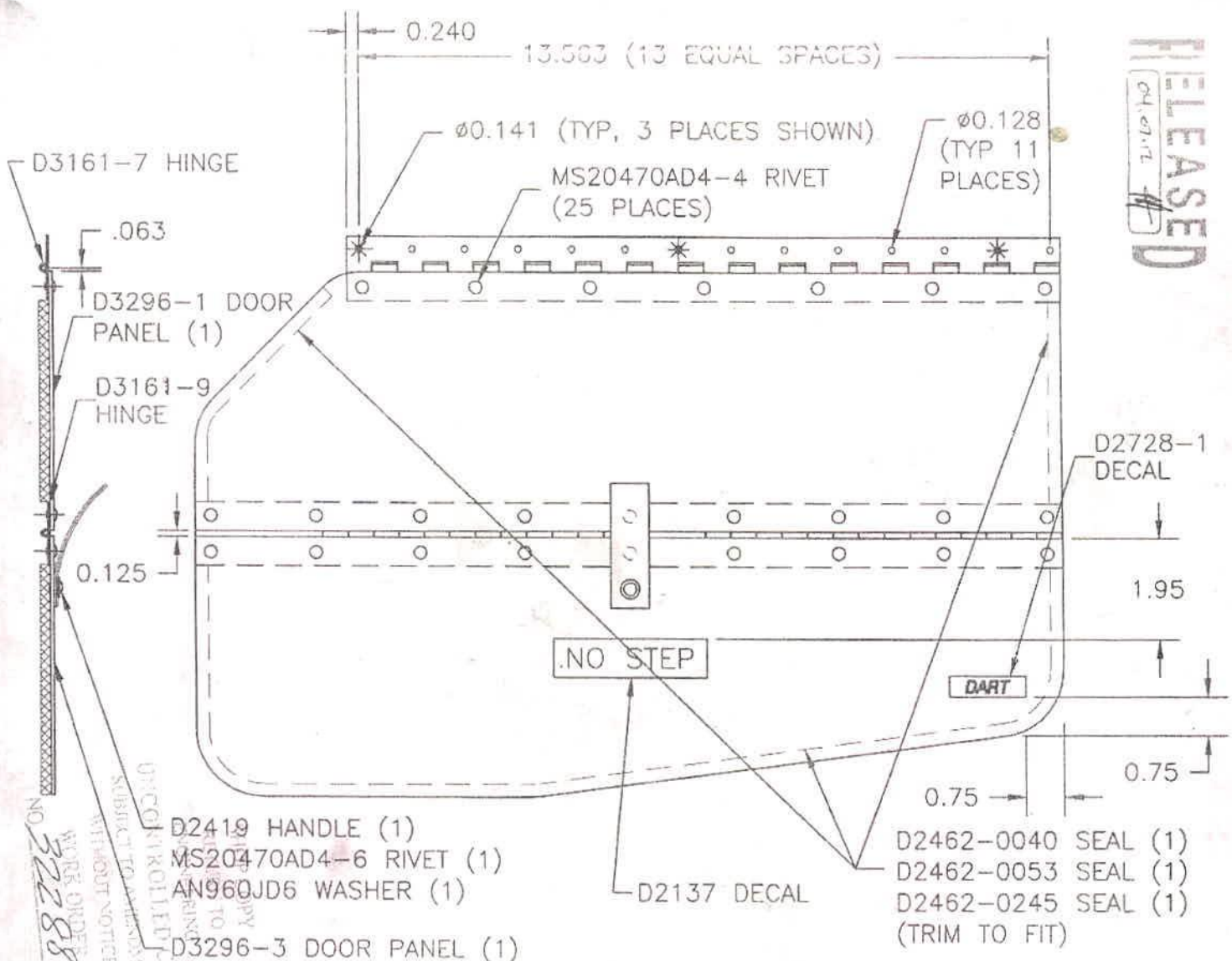
u J. dady

DART



RELEASED
04.07.12

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. A
DATE		D3296	1 OF 2
04.06.28		TITLE	SCALE
		DOOR ASSEMBLY	1:3
A	04.06.28	NEW ISSUE	



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED